

**ABSTRACT:**

An injection-molding machine includes various devices for increasing production efficiency and protecting the mold from closing on molded articles. A method for increasing production efficiency and protecting the mold from closing on articles, or portions thereof, is disclosed. This detection system and method determines if a molded article, or portion thereof, remains in the mold after the first ejection sequence has occurred. This condition is determined by the article-detection controller which enables the molding machine controller to perform the next molding cycle if the said molded article, or portion thereof, is not detected in said mold. The article-detection controller enables the molding machine controller to perform an additional ejection sequence on the mold ejector system if said molded article, or portion thereof, is detected in said mold. If the molded article, or portion thereof, is detected in said mold after the second ejection, subsequent ejection sequences and inspections are performed to self-correct the problem. After exhausting the predetermined number of ejection sequences, the molding machine controller will signal for alternative intervention.